D2565-103
B117829

Work Order ID 117829

117829

May-05-14 11:45:20 AM

Item ID: D2565-103 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Strut

Start Date: 5/12/14 **Start Qty:** 6.00 *6*
Required Date: 5/12/14 **Req'd Qty:** 6.00 *6*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** MCJ **Date:** 14-05-06 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D2565 / Rev E									
100	Punch ends and deburr as per dwg	0.00			DAS 30 9-89				14/06/09
100	NC BRAKE								
Brake NC	**Memo**	0.00							
Brake NC	Punch to length as per Dwg D2565 using DT8313								
110		0.00							
110	Small Fab					6x			14/07/04 DAS 36 9-89
Small Fab	**Memo**	0.00							
Small Fab	1-Drill hole open to .316 Ø as per Dwg D2565 (one end only) 2-Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00			DAS 27 9-89	6			MHly
120									
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

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Work Order ID 117829

11:45:20 AM

Accept *N900040100*

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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M 135954	0.00				6	0	14-7-8	DAS 27 9-89
130 Powdercoat Powder Coating	**Memo** START TIME: 11:00 OVEN TEMPERATURE: 400 FINISH TIME: 11:35	0.00							
	QC3- Inspect Part Finish	0.00				6			
140		0.00							
140 QC Quality Control	**Memo**								
	Identify as per dwg & Stock Location: 71354	0.00				6x		14-7-8	
150		0.00							
150 Packaging Packaging	**Memo**								

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DART AEROSPACE

Work Order update only ☐

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Part No. _____

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☐ Set-up
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☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

May-05-14 11:45:20 AM

Work Order ID: 117829 *117829*

Parent Item: D2565-103 *D2565-103*

Parent Item Name: Strut

Start Date: 5/12/14 **Required Date:** 5/12/14

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP: F02.04.16Added dwg Rev.C1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	123.7261	1.5175	10			
M304TR0.750W.049									**			DAS 30 9-89	4/6/09
304 RD Tube .750 x .049W													

Location	Loc Qty	Loc Code	
MAT017	123.7261		
122312	4.04		
124768	49.27		
M126183	25.4399		
M128084	44.9762		
	M129199		12

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Work Order update only ☐

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☐ Other

DART AEROSPACE LTD

Description: Strut | Work Order: 117809

Inspection Drawing: D2565 | Rev: E | Part Number: D2565-103

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.21	+/-.030	18.22	✓		T	SS-5
17.41	+/-.030	17.42	/		T	SS-5
.8316	+/-.005					

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*)
DAS 30 9-89	DAS 36 9-89	DAS 27 9-89	
Date 14/06/09	Date 14/06/09	Date 14/7/9	Date